

Work Order ID 51629

August 27, 2009 8:27:52 AM



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Item ID: D412-698-032
Revision ID: E
Item Name: Cabin Door Roller, RH

Accept



Setup Start



Stop



Start Date: 8/27/09 Start Qty: 2.00
Required Date: 9/07/09 Req'd Qty: 2.00



Cust Item ID:
Customer:

Reference:

Approvals:

Process Plan:

RP MD

Date:

08/27/09

Tooling:

Date:

Run Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-698

Rev E

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile & type labels per PPP D412-698-032

CHG001

Scal/10/01

9/9/25 BG 09/09/25

110

0.00



Packaging

Packaging

Pick Kit

Memo

0.00

9/9/25 (2x) SP

120

0.00



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

Scal/10/01

(2) 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start

Stop

QC:

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SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Packaging

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-698-031 Location: _____ PPP Rev: _____

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/14/09 (2)

09/10/09

PL 09-10-2

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Picklist Print

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Work Order ID: 51629

Parent Item: D412-698-032RevE

Parent Item Name: Cabin Door Roller, RH

Start Date: 8/27/09

Required Date: 9/07/09

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3121-144RevE		Manufactured	No			120	Each	15.0000	2.0000			



Bracket Assembly

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 15

43604 5

45086 10

120 Each 48.0000 2.0000



45086 SP

D3137-043RevF

Manufactured No



Bracket Assembly

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 48

29725 4

42192 44

120 Each 29.0000 2.0000



42192 SP

9/6/25

D3183-044RevC1

Manufactured No



Bracket Assembly

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 29

42194 23

47646 6

42194 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Parent Item: D412-698-032RevE

Parent Item Name: Cabin Door Roller, RH

Comments:

Start Date: 8/27/09

Required Date: 9/07/09

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3202-3RevD

Manufactured

No

120

Each

9.0000

2.0000



S
+2
Cover

B52284 sf
9/10/11

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

9

SCRAP →

42516

9

42516

D3674-041RevA

Manufactured

No

120

Each

48.0000

6.0000



S
+2

BRACKET ASSEMBLY

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

48

40122

3

42514

39

47645

6

500
42514

D3675-1RevB

Manufactured

No

120

Each

84.0000

18.0000



S

SLIDING DOOR BRACKET

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

84

40347

4

42515

80

9/9/25 sf
9/9/28 sf
(5) B52168
(13) 42515 sf

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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8.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 412-030-300-XXX COMPOSITE DOORS)

Qty -019	Qty -021	Qty -031	Qty -032	Qty -033	Qty -035	Part Number	Description
X						D412-698-019	BEARING OVERHAUL KIT
	X					D412-698-021	REPLACEMENT SHIM KIT
		X				D412-698-031	CABIN DOOR ROLLER KIT, LH
			X			D412-698-032	CABIN DOOR ROLLER KIT, RH
				X		D412-698-033	REPLACEMENT DOOR TRACK KIT
					X	D412-698-035	DOOR HANDLE KIT
7						D3121-21	BOLT
5						D3121-241	BEARING ASSEMBLY
1						D3137-3	GUIDE
1						D3137-5	WASHER
2						D3183-045	BEARING ASSEMBLY
	3					D3238-1	SHIM
	1					D3238-3	SHIM
	2					D3238-5	SHIM
	6					D3238-11	SHIM
	2					D3238-13	SHIM
	4					D3238-15	SHIM
		1				D3121-143	BRACKET ASSEMBLY
			1			D3121-144	BRACKET ASSEMBLY
		1				D3137-043	BRACKET ASSEMBLY
		1				D3183-043	BRACKET ASSEMBLY
						D3183-044	BRACKET ASSEMBLY
		1	1	1		D3202-3	COVER
		3	3			D3674-041	BRACKET ASSEMBLY
		9	9	9		D3675-1	BRACKET
					2	D3779-041	HANDLE ASSEMBLY
					2	D3779-3	PLATE
					2	D3779-043	HANDLE ASSEMBLY
					12	AN525-832R8	SCREW
					12	AN960JD10L	WASHER
					12	MS21042L3	NUT
					12	MS24694-S58	SCREW
1						MS24694-S101	SCREW

51269

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Revision: E

Date: 08.05.01